

Date: Monday, 15/06/2009 4:20:00 PM
 User: Julie Dawson

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : REAR OVERHEAD L/H, IVORY
Job Number : 48591A	
Estimate Number : 13589	
P.O. Number :	Part Number : D38231KIV
This Issue : 15/06/2009 S.O. No. :	Drawing Number : D3823-1
Prsht Rev. : NC	Project Number :
First Issue : / / Type : THERMOFORMING	Drawing Revision :
Previous Run : 47670A	Material : MKYD6185S080P362015
Written By :	Due Date : 22/06/2009 Qty: 3 Um: Each
Checked & Approved By : <u>JUD 09.06.15</u>	
Comment : Est. A New Issue 08/09/17 DL Rev B Dwg. Update 09/02/09 DL verified by:DD Est Rev C Add Colour Code 09/06/02 DL	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	MKYD6185S080P362015	6185 KYDEX .080"
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Comment: Qty.: 11.3747 sf(s)/Unit Total : 56.8733 sf(s)
 6185 Kydex .080" Ivory

M109703

BB 09/06/22

2.0	HAND FINISH TH	HAND FINISHING THERMOFORMING
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**Comment:** HAND FINISHING THERMOFORMING

1) Machine set up

BB 09/06/22

3.0	HAND FINISH TH	HAND FINISHING THERMOFORMING
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**Comment:** HAND FINISHING THERMOFORMING

1) Cut sheet to required blank size

BB 09/06/22 X 3

4.0	THERMOFORMING	THERMOFORMING MACHINE
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**Comment:** THERMOFORMING MACHINE

Thermoform as per Dwg. D3823-1 and folio FTA 030 using tool DT 9112

Dwg. Rev. SFolio Rev. B

BB 09/06/22 X 3

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Seq. #:	Machine Or Operation:	Description :
---------	-----------------------	---------------

5.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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Comment: INSPECT PARTS AS THEY COME OFF MACHINE

Visually inspect for proper formation of each part

BB 09/06/22 (X3)

6.0	QC8	SECOND CHECK
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Comment: SECOND CHECK

W/L 09/06/22 (X3)

7.0	HAND FINISH TH	HAND FINISHING THERMOFORMING
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Comment: HAND FINISHING THERMOFORMING

1) Trim to Finished Dimensions

W/L 09/06/23

8.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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Comment: INSPECT PARTS AS THEY COME OFF MACHINE

Check dimensions to ensure conformity to drawing tolerances.

W/L 09/06/23

9.0	QC5	INSPECT WORK TO CURRENT STEP
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Comment: INSPECT WORK TO CURRENT STEP

S 09/06/23 (X3)

10.0	PACKAGING 1	PACKAGING RESOURCE #1
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Comment: PACKAGING RESOURCE #1

Identify and Stock
Location: _____

9/6/23

(3)

SP

11.0	QC21	FINAL INSPECTION/W/O RELEASE
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Comment: FINAL INSPECTION/W/O RELEASE

09/06/23

Job Completion



mf 09-06-23

W/O:		WORK ORDER CHANGES					
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DART AEROSPACE LTD	Work Order: 48591A
Description:	Part Number: D3823-1 R/V
Inspection Dwg: D3823-1 Rev: C	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

THERMOFORMING SECTION

Description	Accept	Reject	Method of Inspection	Comments
Inside Radii less than <u>N/A</u> "				
Shape Definition	✓			
Texture Retention	✓			
Material imperfections such as bumps, cracks, voids, scratching	✓			

Measured by: Wh

Date: 09/06/23

TRIMMING SECTION

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
0.5"	MIN	0.575"	✓			
0.444	MIN	0.6"	✓			
1.75"	MIN	1.81"	✓			
0.045"	MIN	0.060"	✓			
0.055"	MIN	0.069"	✓			

Measured by: Wh

Date: 09/06/23

Audited by: JB

Date: 09/06/23

Prototype Approval:

Date:

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/DL	

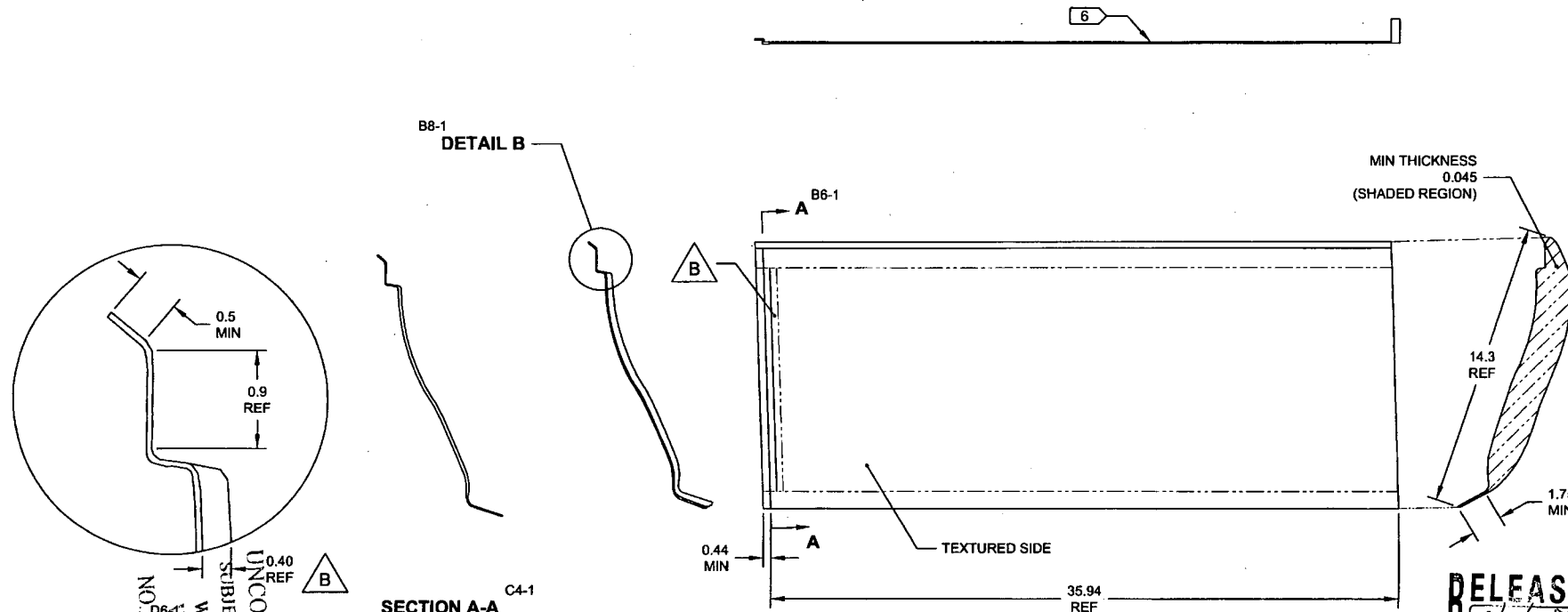
8 7 6 5 4 3 2 1

D

C

B

A



DETAIL B
SCALE 5X

NO. 1855117
WORK ORDER
WITHOUT NOTICE
SUBJECT TO AMENDMENT
UNCONTROLLED COPY
ENGINEERING
RETURN TO
SHOP COPY

SECTION A-A

D3823-1 REAR OVERHEAD, LH

- NOTES:**
- 1) MATERIAL: SEE TABLE
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: IDENTIFY WITH DART P/N (SEE TABLE) USING VIBRATING STYLUS
 - 7) WEIGHT: 1.9 lbs
 - 8) TOOLING: THERMOFORM PER MOLD DT9112 PER DART QSI 022. TRIM PER MOLD
 - 9) MINIMUM THICKNESS: 0.055" UNLESS OTHERWISE NOTED

C
C

PART NUMBER	DESCRIPTION
D3823-1KIV	KYDEX 6185, 0.080 THICK, P3-VELOUR MATTE, IVORY #62015 (MKYD6185S.080-P3-62015)
D3823-1KGY	KYDEX 6185, 0.080 THICK, P3-VELOUR MATTE, STEEL GRAY #52068 (MKYD6185S.080-P3-52068)

C	ADD STEEL GRAY COLOUR OPTION, ADD IVORY P/N'S D3823-1/2-3(KIV) AND ADD STEEL GRAY P/N'S D3823-1/2-3(KGY) (ZN A5-1, A5-2, A5-3)	PH	09.05.05
B	ADD JOGGLE TO D3823-1/2-3 FOR BETTER FIT WITH D3824-1/3 HAT BIN (ZN C5-1, C5-2, C8-3); 0.40 WAS 0.18 (ZN B7-1, D7-2); 0.45 WAS 0.29 (ZN B8-3)	PH	09.02.09
A	NEW ISSUE	PH	08.09.26
REV.	DESCRIPTION	BY	DATE
DESIGN			
DRAWN			
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	09.05.05		

DART AEROSPACE LTD
HAWKESBURY, ONTARIO, CANADA

DRAWING NO. D3823
REV. C
SHEET 1 OF 3
TITLE REAR OVERHEAD
SCALE NTS

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